

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017385**Date Inspected:** 09-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of repair weld is identified as 2G-004 of SB017-086 for SB86W. The welder is identified as 062786. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-Repair and WR15626.

FCAW welding of repair weld is identified as 2G-037 of SB020-086 for SB86E. The welder is identified as 062762. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-Repair and WR15676.

FCAW welding of repair weld is identified as 2G-004 of SB017-090 for SB90W. The welder is identified as 062732. ABF QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-2G-Repair and WR15638.

FCAW welding of weld is identified as 2F-021 of BK004A2-012 for BK004A-012. The welder is identified as 062806. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

FCAW welding of weld is identified as 2F-013 of BK004A2-012 for BK004A-012. The welder is identified as

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

062749. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132.

FCAW welding of weld is identified as 3G-007 of BK005ASD1-001 for BK005A-001. The welder is identified as 062783. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 1G-018 of BK006A2-002 for BK006A-002. The welder is identified as 062734. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-B-L1b-F-1.

ZPMC personnel carried out plug welds crack repair work in night shift of bike path bottom cover plate without information and without made any report, the bike path is identified as BK004A-011. The weld no are identified as follows.

BK004A2-011-014,015,017,019,020.

ZPMC personnel performing internal cleaning before fit-up of End closure plate of bike path is identified as BK004A-003.

During visual inspection of bike path BK004A-002 internal cleaning, it is observed that internal components like deck plate, stringer plate, and stiffener have rust; It is very hard to remove.

Where ever need additional cleaning and grinding marked and ZPMC personnel carried out The repair work. For more information please see the attached photos.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A6-007-061,065,080,078,092,088,096  
BK004A8-007-063,070,080,082,078,090,100  
BK006A2-001-016,018

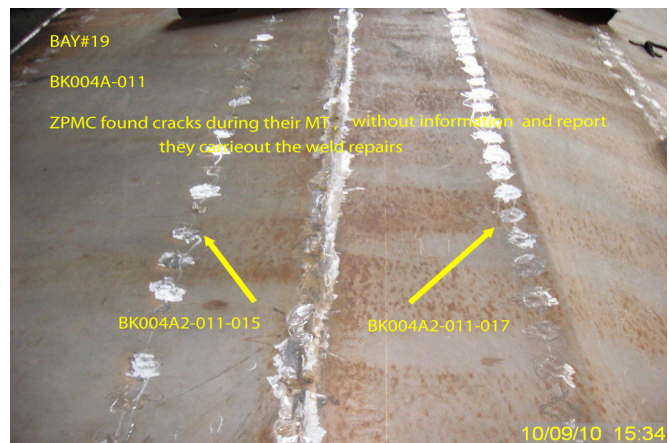
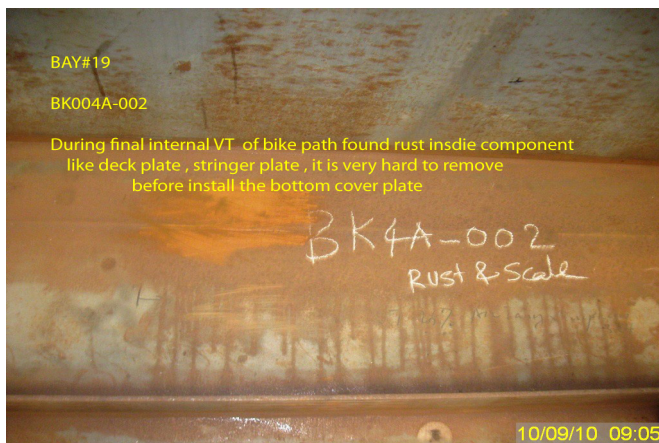
This QA inspector performed (Re-MT) MT 15% of heat straightened weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A3-003-0025, 026  
BK004A4-003-014,015  
BK004A6-003-150,151,155,024,036  
BK004A8-003-024,121,123,126

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )



## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

---

## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

---

<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

---